

Screw 57013

Work Order ID 52350

Tuesday, September 22, 2009 12:26:35 PM



Page 1

Item ID: D3017-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Back Frame Assembly

Start Date: 9/23/2009 Start Qty: 3.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 3.00

Customer:

Reference:

Approvals: Process Plan:

RL/mk

Date: 9-9-22

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3017

Rev A

1/B w per DSI 9498 10-03-04

100

0.00



Large Fab

EL 9-9-24

Large Fab

Memo

0.00

Large Fab

1-Cut all tubes as per Dwg D3017

2-Bend tube as per dwg D3017

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

A/R 4130 Rod Batch: *100075*

6-Drill holes in back frame using back pan

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



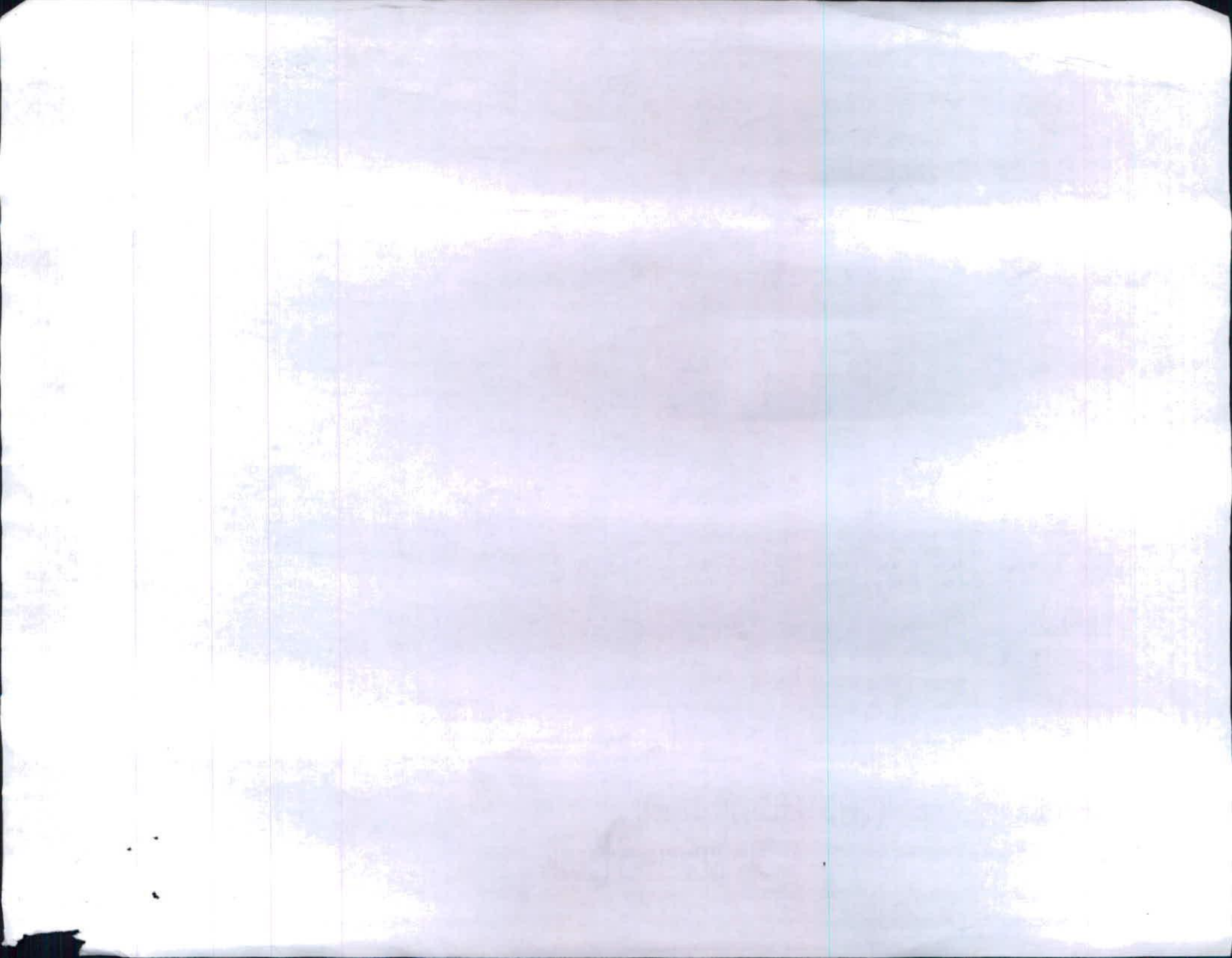
QC

Memo

0.00

Quality Control

BE 10/03/10



Work Order ID 52350

Tuesday, September 22, 2009 12:26:35 PM

Page 2

Item ID: D3017-041

Revision ID: A

Item Name: Back Frame Assembly

Start Date: 9/23/2009 Start Qty: 3.00

Required Date: 10/9/2009 Req'd Qty: 3.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 10:00AM
OVEN TEMPERATURE: 320°F
FINISH TIME: 10:30AM

140

QC3- Inspect Part Finish

0.00

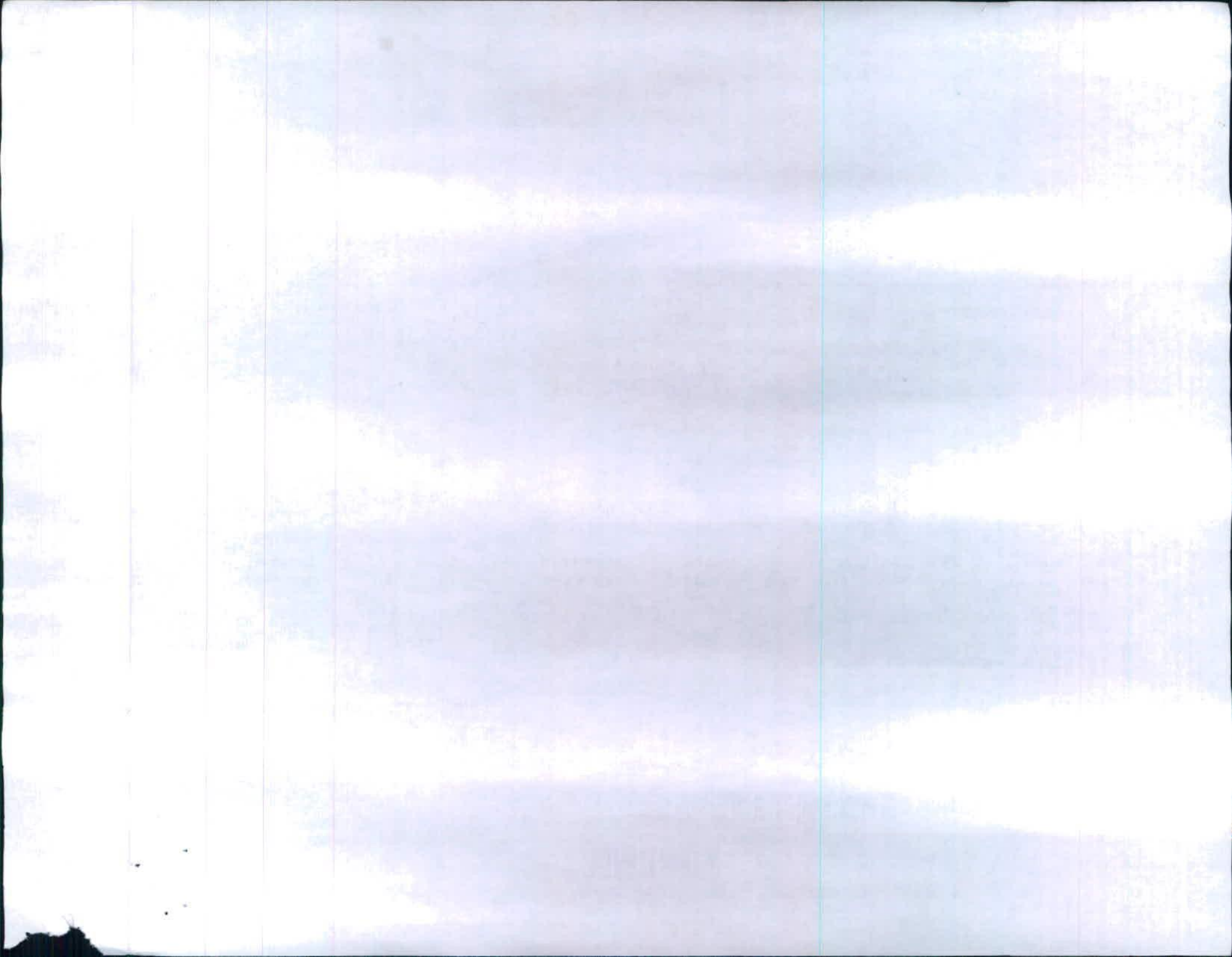


QC

Memo

0.00

Quality Control



Work Order ID 52350

Tuesday, September 22, 2009 12:26:35 PM

Page 3

Item ID: D3017-041

Revision ID: A

Item Name: Back Frame Assembly

Start Date: 9/23/2009 Start Qty: 3.00

Required Date: 10/9/2009 Req'd Qty: 3.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: G-A

0.00



Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00



QC

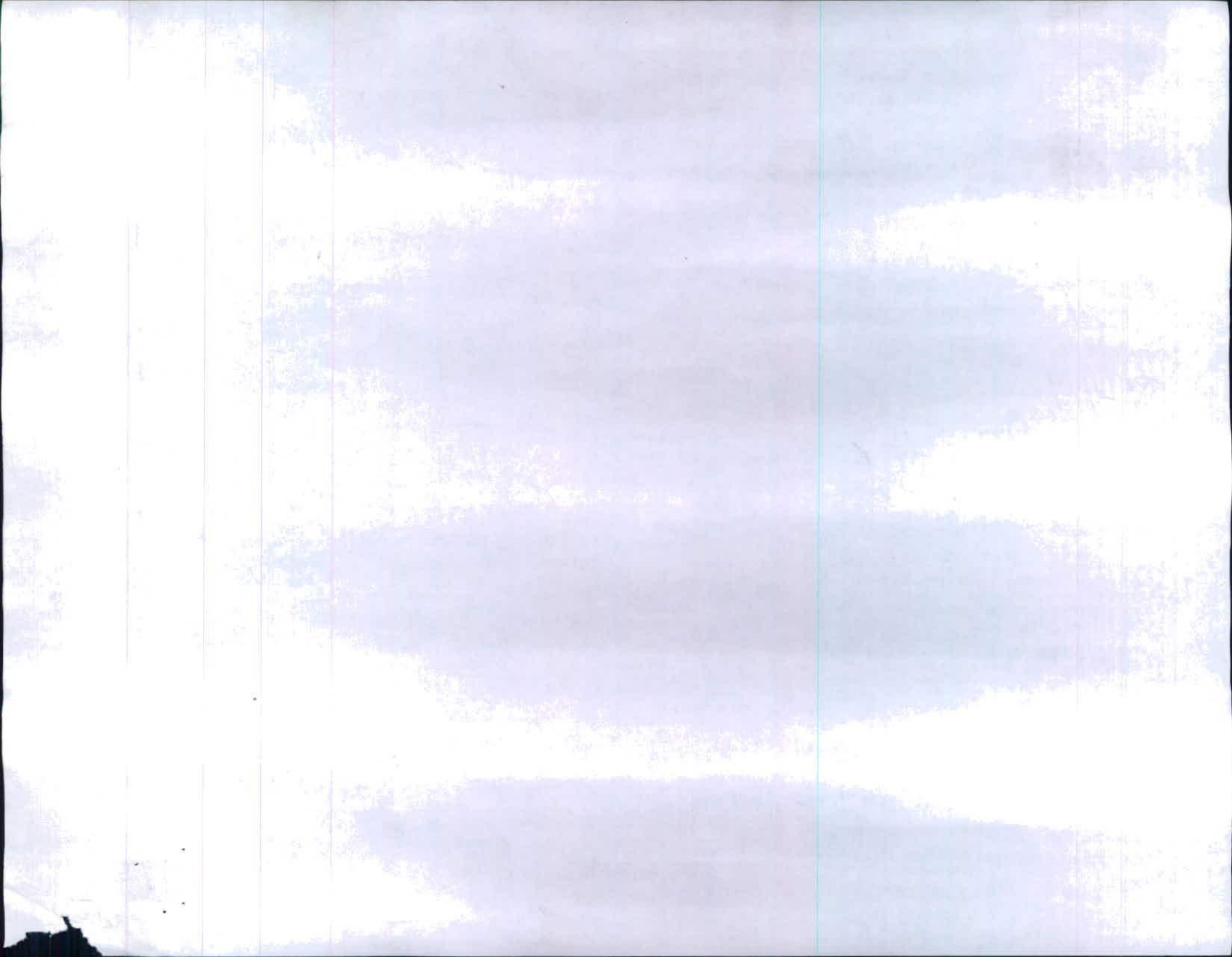
Memo

0.00

Quality Control

ES 10/03/16 @

10/03/17 AJ
MF
10-3-16



Picklist Print

Tuesday, September 22, 2009 12:26:35 PM

Page 1

Work Order ID: 52350

Parent Item: D3017-041RevA

Parent Item Name: Back Frame Assembly

Comments:

Start Date: 9/23/2009

Required Date: 10/9/2009

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4130NT0.750W.049		Purchased	No			100	f	167.5700	39.4737			
4130 RD Tube .750 x.049W												

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
MAT	167.57	
10133	12.75	
103012	3	
10498	0.04	
110740	127.01	
11105	24.77	

D3017-11RevA
cap
Manufactured No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	12	
44779	12	
100	Each	12.0000 6.0000

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	12	
44779	12	
100	Each	6.0000 9.0000

D3017-7RevA
Lug
Manufactured No

Warehouse	Loc Qty	Loc Code
Location		
Main Warehouse		
ST	6	
38567	6	

per
M4130NT0.750W.083

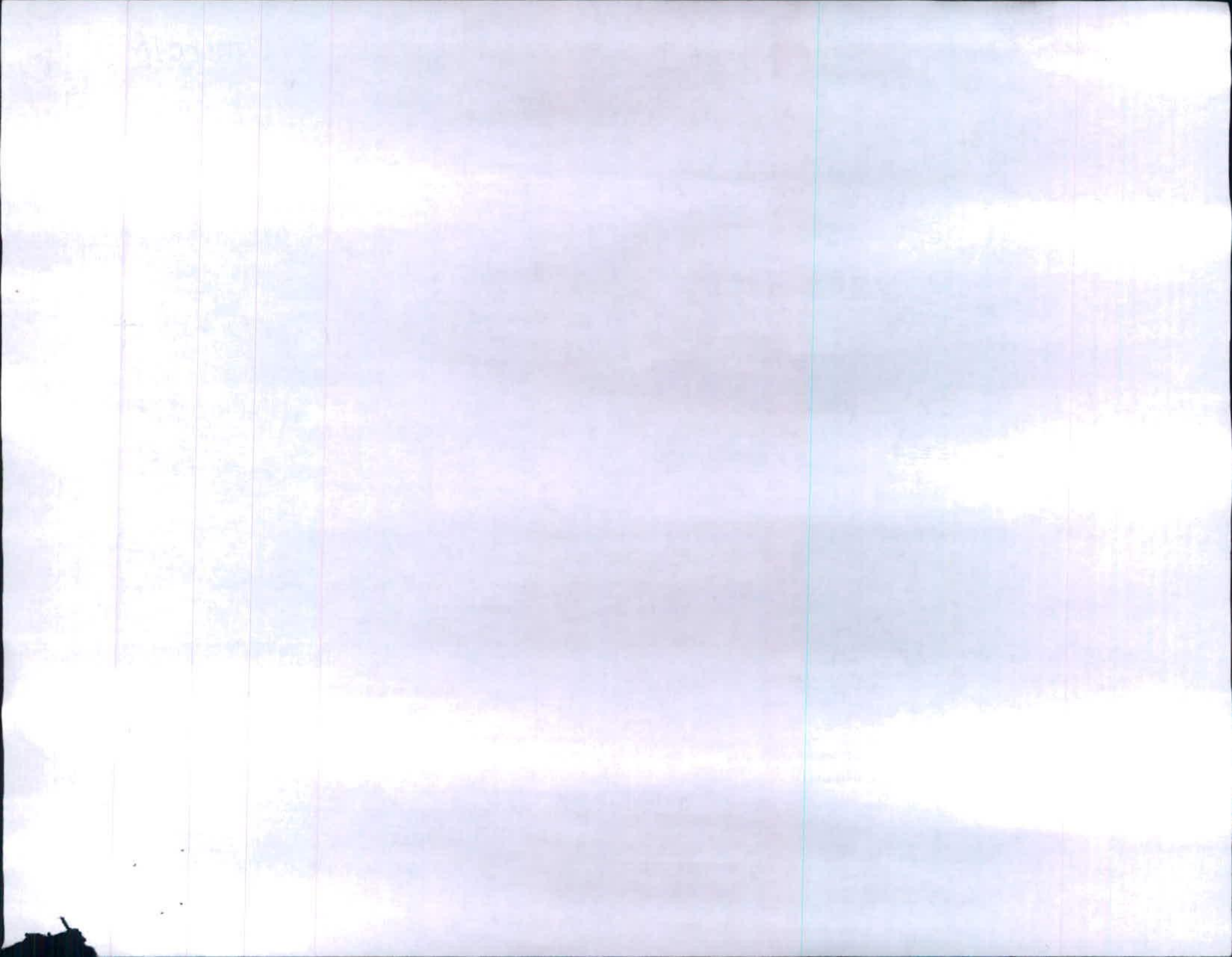
2.46'

B113812 x 2.5'

EL 9-9-24

EL 9-9-24

EL 9-9-24





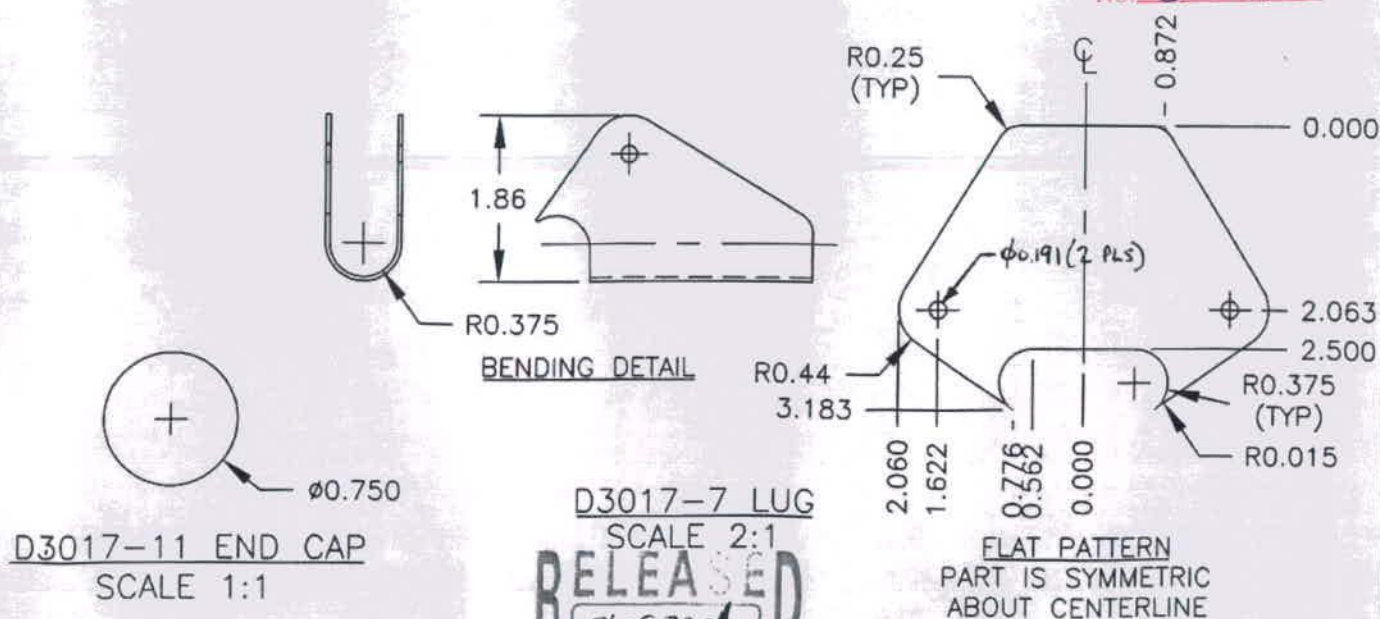
DESIGN	UP	DRAWN BY	UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D3017	REV. A SHEET 1 OF 2
DATE	01.05.18			TITLE BACK FRAME ASSEMBLY	SCALE 1:1
A	01.05.18			NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

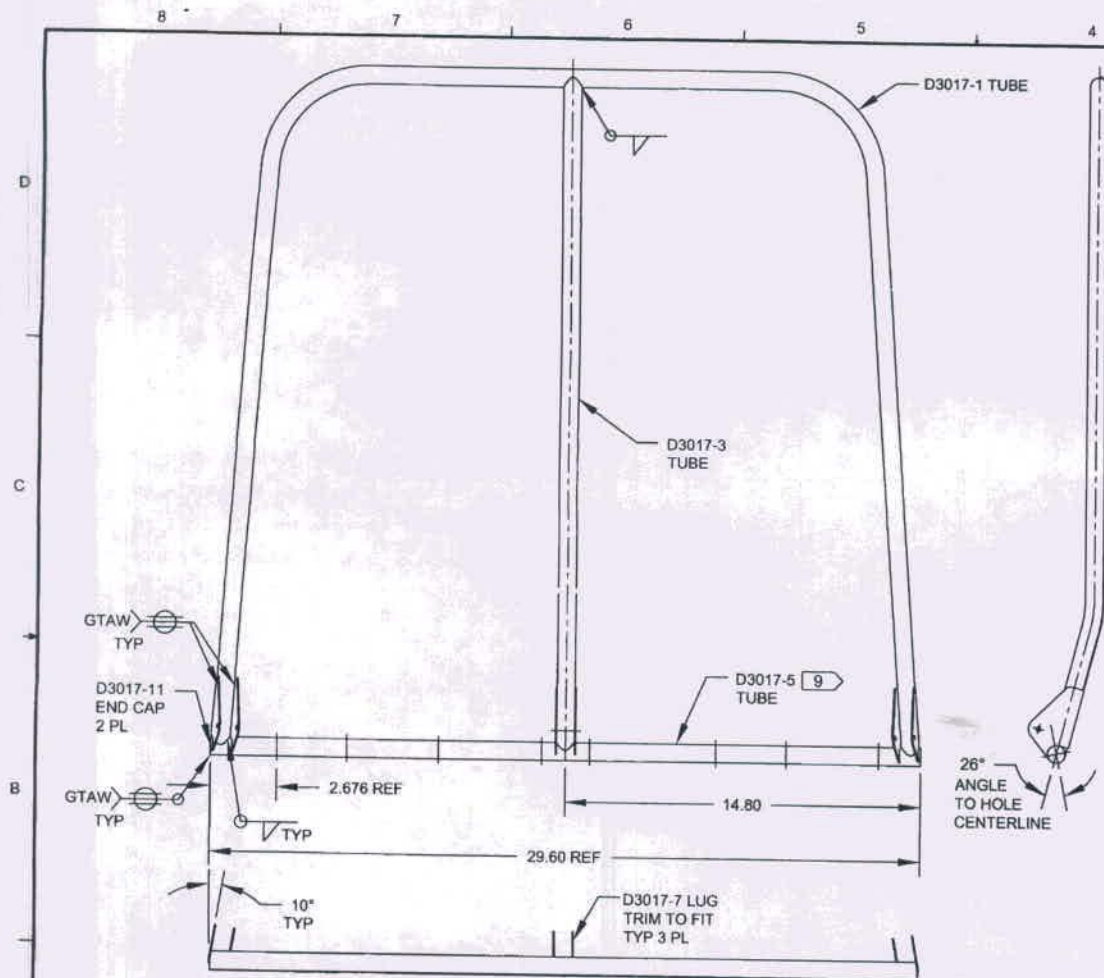
- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52350



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ITEM No.	QTY	PART NUMBER	DESCRIPTION
1	X	D3017-041	BACK FRAME ASSEMBLY
2	1	D3017-1	TUBE
3	1	D3017-3	TUBE
4	1	D3017-5	TUBE
5	3	D3017-7	LUG
6	2	D3017-11	END CAP

DRILL Ø0.128 HOLES TO LINE UP WITH D3023-1 BACK PANEL

26°
ANGLE TO HOLE CENTERLINE

WLO 52350

RELEASED
2010-02-02
MP

D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004
- 9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

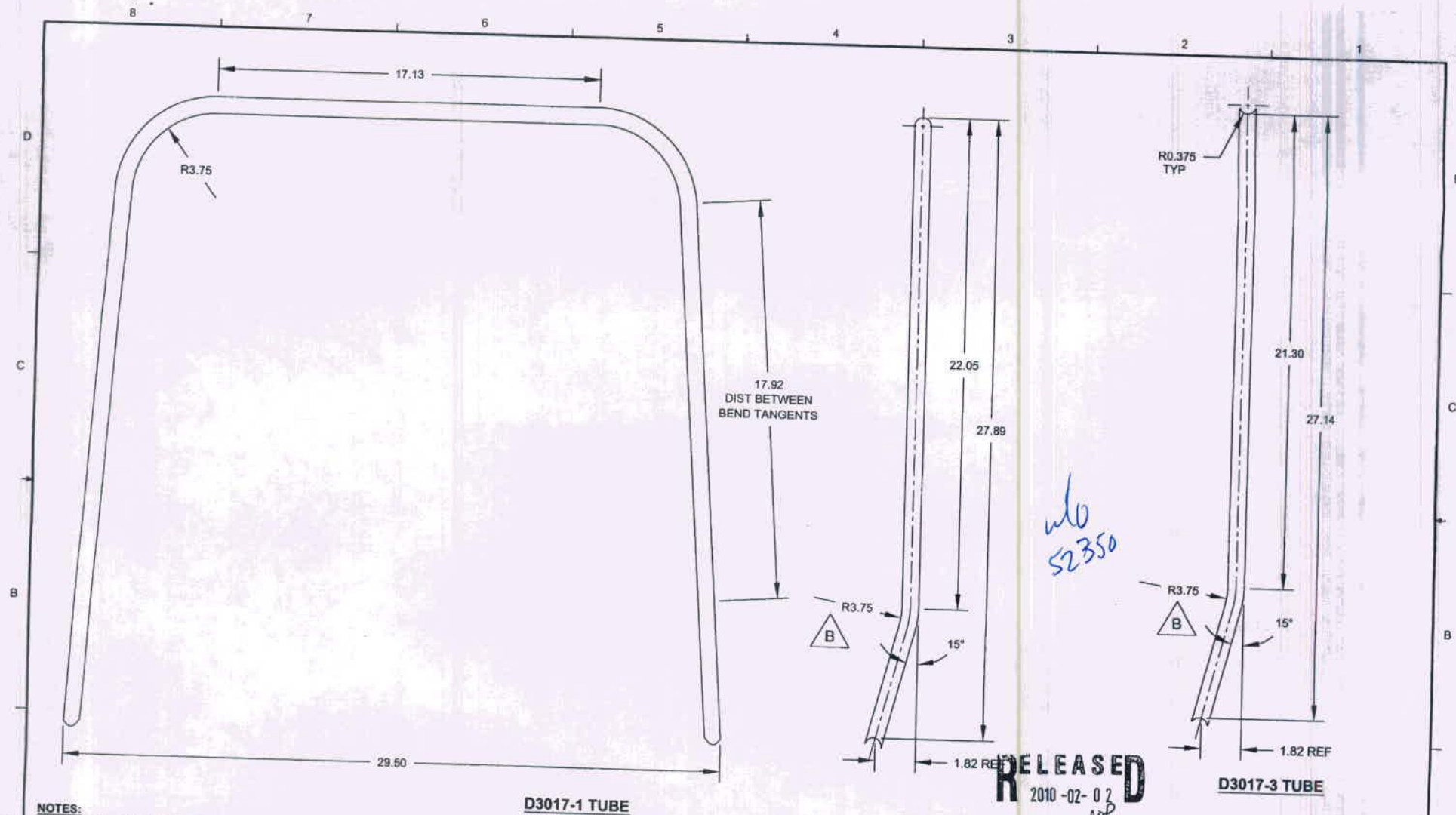
B	REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3)	JPH	10.01.13
A	NEW ISSUE	CP	01.05.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.01.13		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B
D3017 SHEET 1 OF 4
TITLE SCALE
BACK FRAME ASSEMBLY NTS

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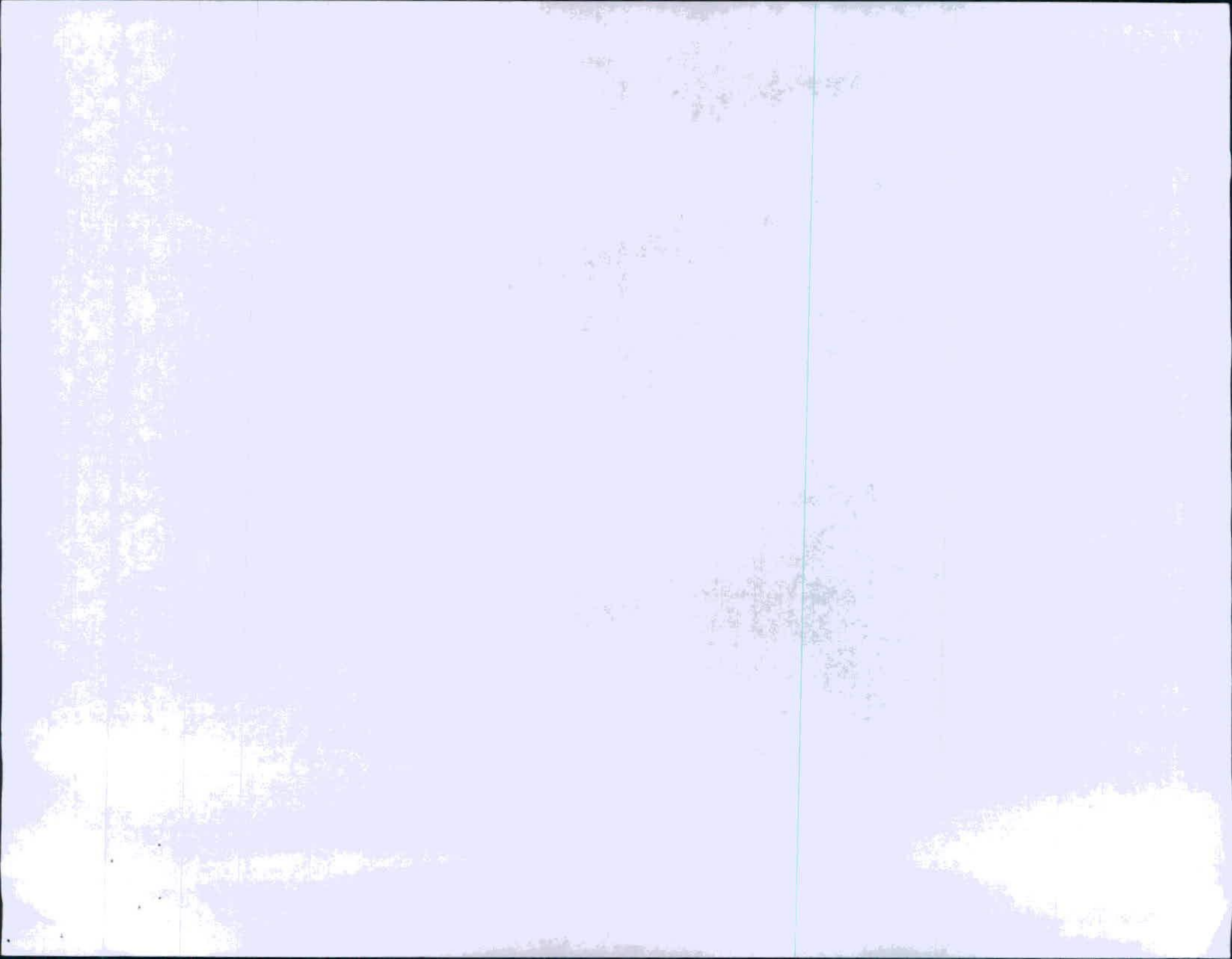


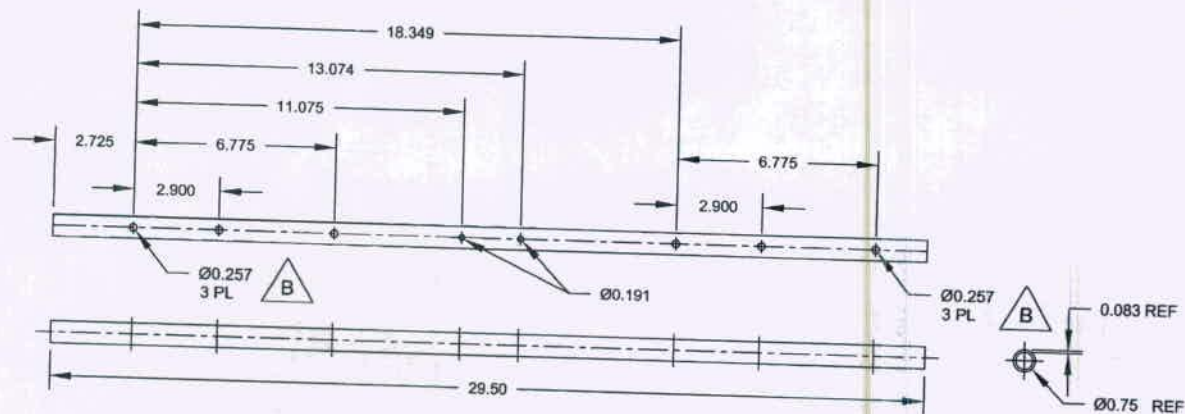


NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D3017-1: 2.38 lbs; D3017-3: 0.84 lbs.

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3017	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BACK FRAME ASSEMBLY	NTS
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D3017-5 TUBE

u/b
5235b

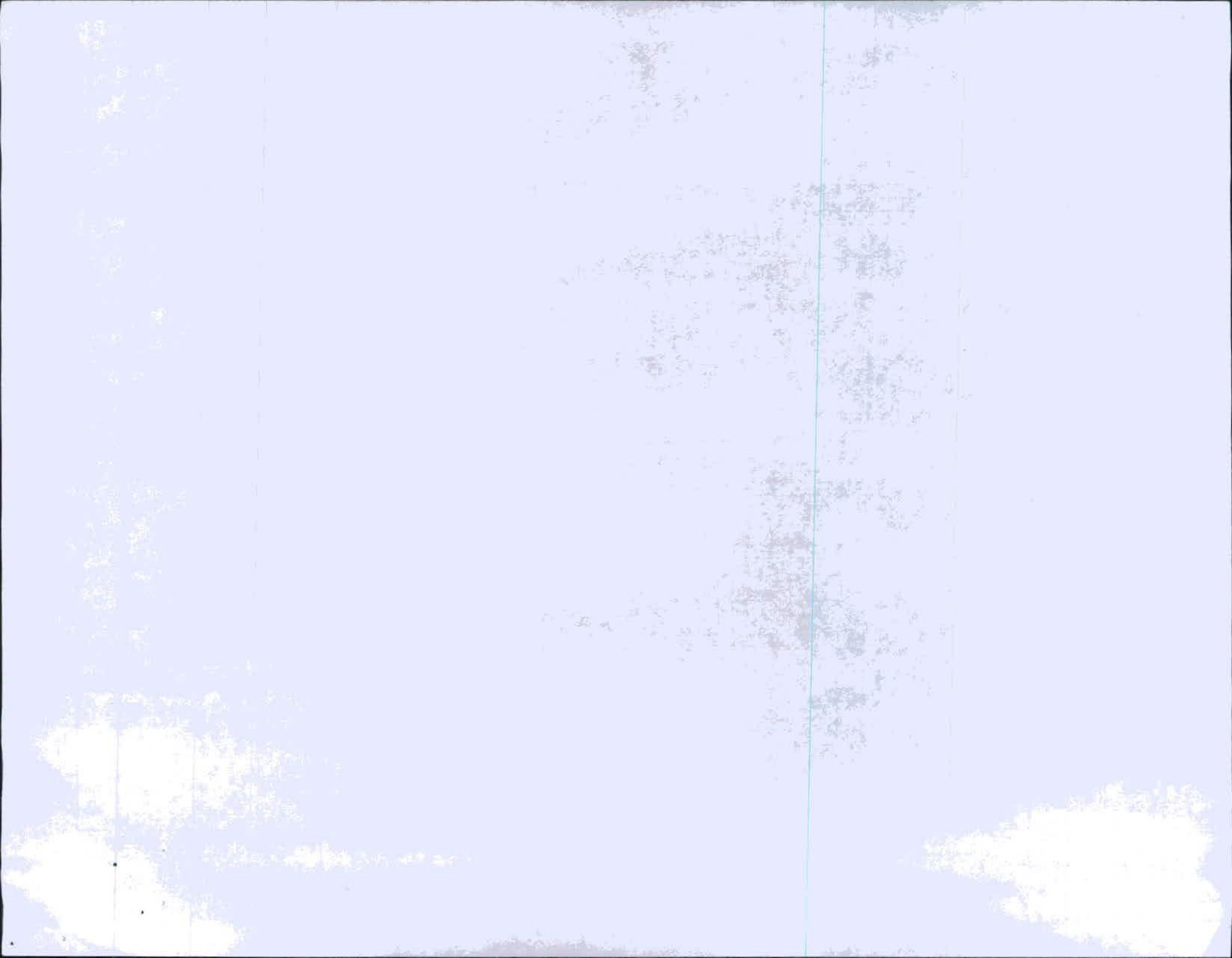
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2010-02-02

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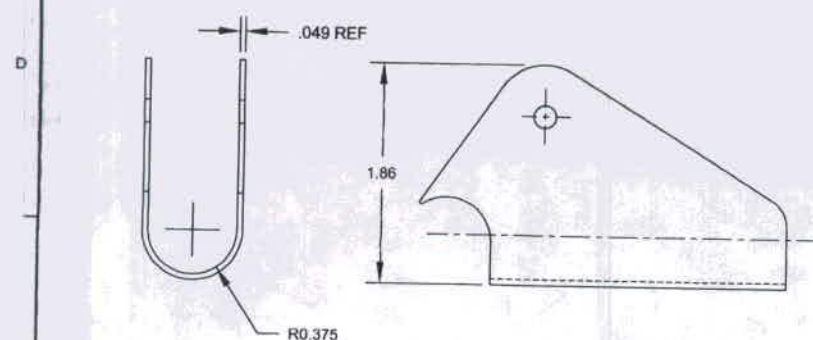
- 1) MATERIAL: AISI 4130N TUBE, 0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



DESIGN			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN					
CHECKED				DRAWING NO.	REV. B
MFG. APPR.				D3017	SHEET 3 OF 4
APPROVED				TITLE	SCALE
DE APPR.				BACK FRAME ASSEMBLY	NTS
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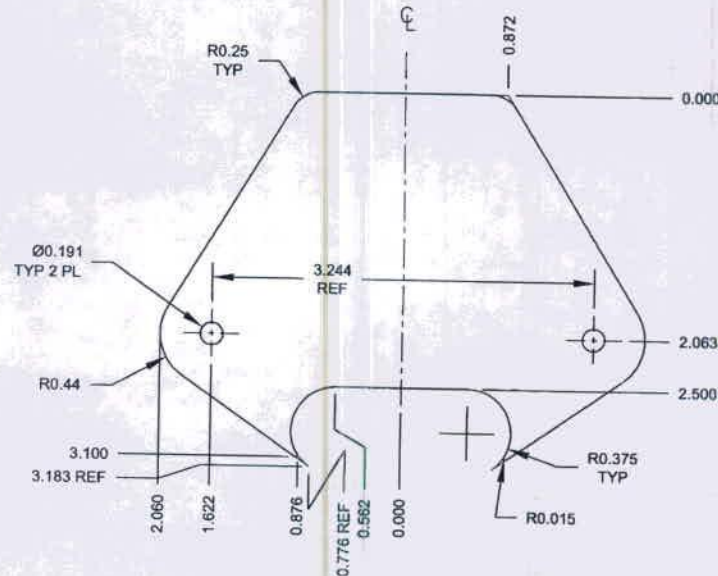
8 7 6 5 4 3 2 1



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

u/w 52350

RELEASED
2010-02-02

- NOTES:**
- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

DESIGN		DART AEROSPACE LTD	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3017	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 REV 0

REF TCCA STC: SH02-33

REF FAA STC: SR01620NY

REF EASA STC: EASA.IM.R.S.01453

REF BRAZILIAN STC: 2005S03-09

PURPOSE:

TO UPDATE THE PARTS LIST AND THE WEIGHT AND BALANCE TABLE IN IIN-D350-689 REV A AND ICA-D350-689 REV 0.

CHANGE:

FOR D350-689-011 AT CHANGE 003, D350-689-021 AT CHANGE 002, D350-689-041 AT CHANGE 002 AND D350-689-043 AT CHANGE 002, QTY (6) OF: MS27039-1-19 SCREW; MS21042L3 NUT & AN960JD10L WASHER REPLACED WITH QTY (6) OF: MS27039-4-21 SCREW; MS21042L4 NUT & NAS1149D0432J WASHER RESPECTIVELY. FIGURE 6 (PG 9) OF IIN-D350-689 MODIFIED PER SHT 2 OF THIS SERVICE INSTRUCTION. THE HARDWARE SECTION OF THE PARTS LIST IN SECTION 5 (PG 10) OF IIN-D350-689 REV A & SECTION 25.6 (PG 31) OF ICA-350-689 REV 0 IS AMENDED AS FOLLOWS:

Qty -011	Qty -013	Qty -021	Qty -023	Qty -041	Qty -043	Part Number	Description
X						D350-689-011	DUAL HIGH BACK SEAT INSTALLATION, LH
1	X					D350-689-013	FLOOR PROVISIONS KIT
		X				D350-689-021	DUAL HIGH BACK SEAT INSTALLATION, LH (REF DSI 9419)
		1	X			D350-689-023	ENERGY ATTENUATING FLOOR PROVISION KIT (REF DSI 9419)
1				X		D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
		1			X	D350-689-043	DUAL HIGH BACK SEAT ASSEMBLY (REF DSI 9419)
6				17	17	NAS1149D0332J	WASHER (OR AN960JD10L)
			9			NAS1149D0363J	WASHER (OR AN960JD10)
			6	6		NAS1149D0432J	WASHER (OR AN960JD416)
			3	3		AN3-12A	BOLT
16						MS20426AD3-6	RIVET
		14				MS20426AD4-5	RIVET
17						MS20426AD4-6	RIVET
18		34				MS20470AD4-5	RIVET
2		18				MS20470AD4-6	RIVET
30		32				MS20470AD5-6	RIVET
				40	40	MS20600AD4W2	RIVET
				6	6	MS20600AD4W3	RIVET (REF DSI 9349)
8						MS21059L3	NUTPLATE
6						MS27039-1-10	SCREW
				4	4	MS27039-1-17	SCREW
				6	6	MS27039-1-19	SCREW
				6	6	MS27039-4-21	SCREW
				4	4	MS24693-S272	SCREW
2						MS24693-S273	SCREW
				8		MS24694-S3	SCREW
		9				MS24694-S50	SCREW
				4		MS24694-S148	SCREW
		9	17	17		MS21042L3	NUT (OR MS21042-3)
			6	6		MS21042L4	NUT (OR MS21042-4)

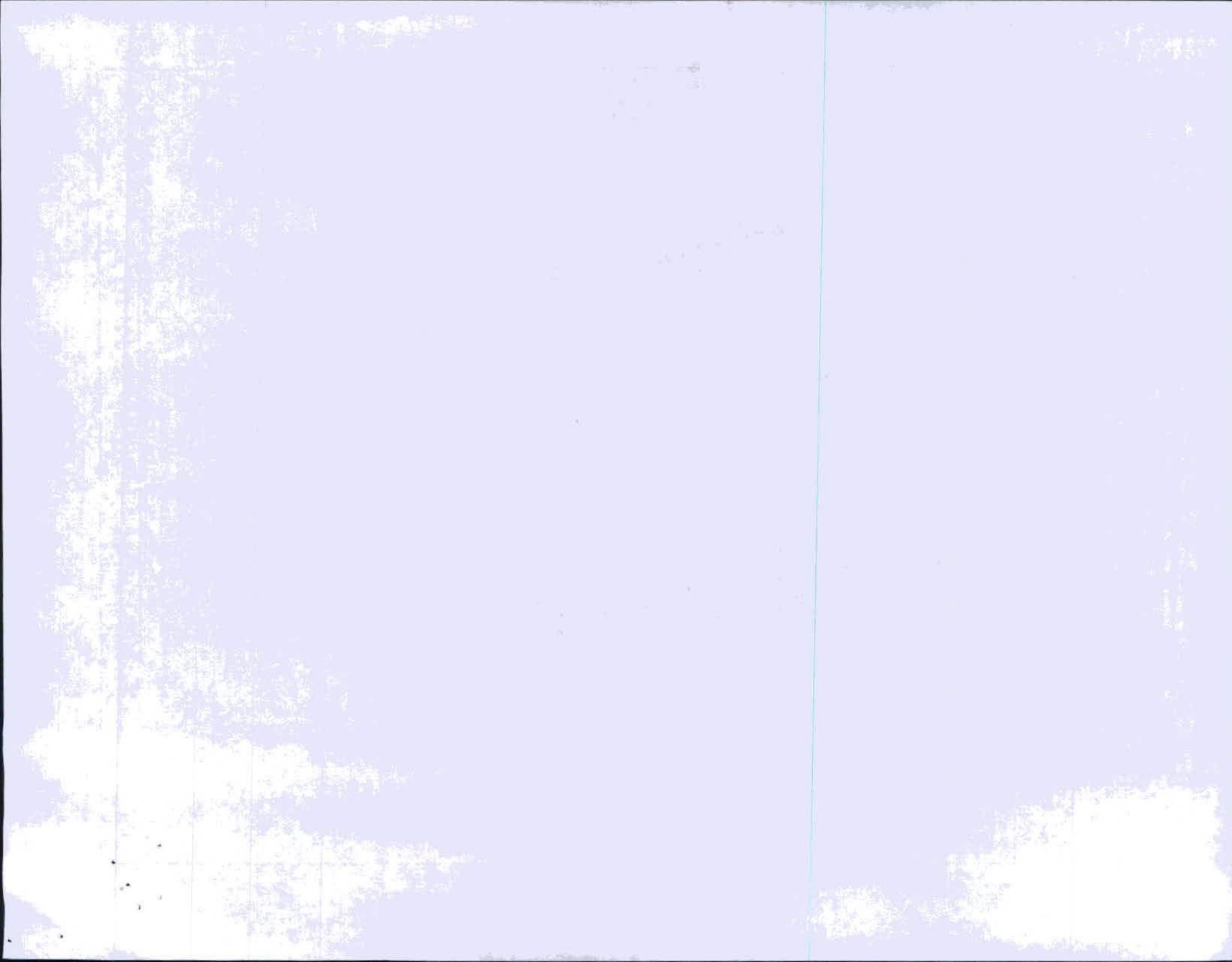
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.01.21
CERT. NO.: SH02-33
ISSUE NO.: 1

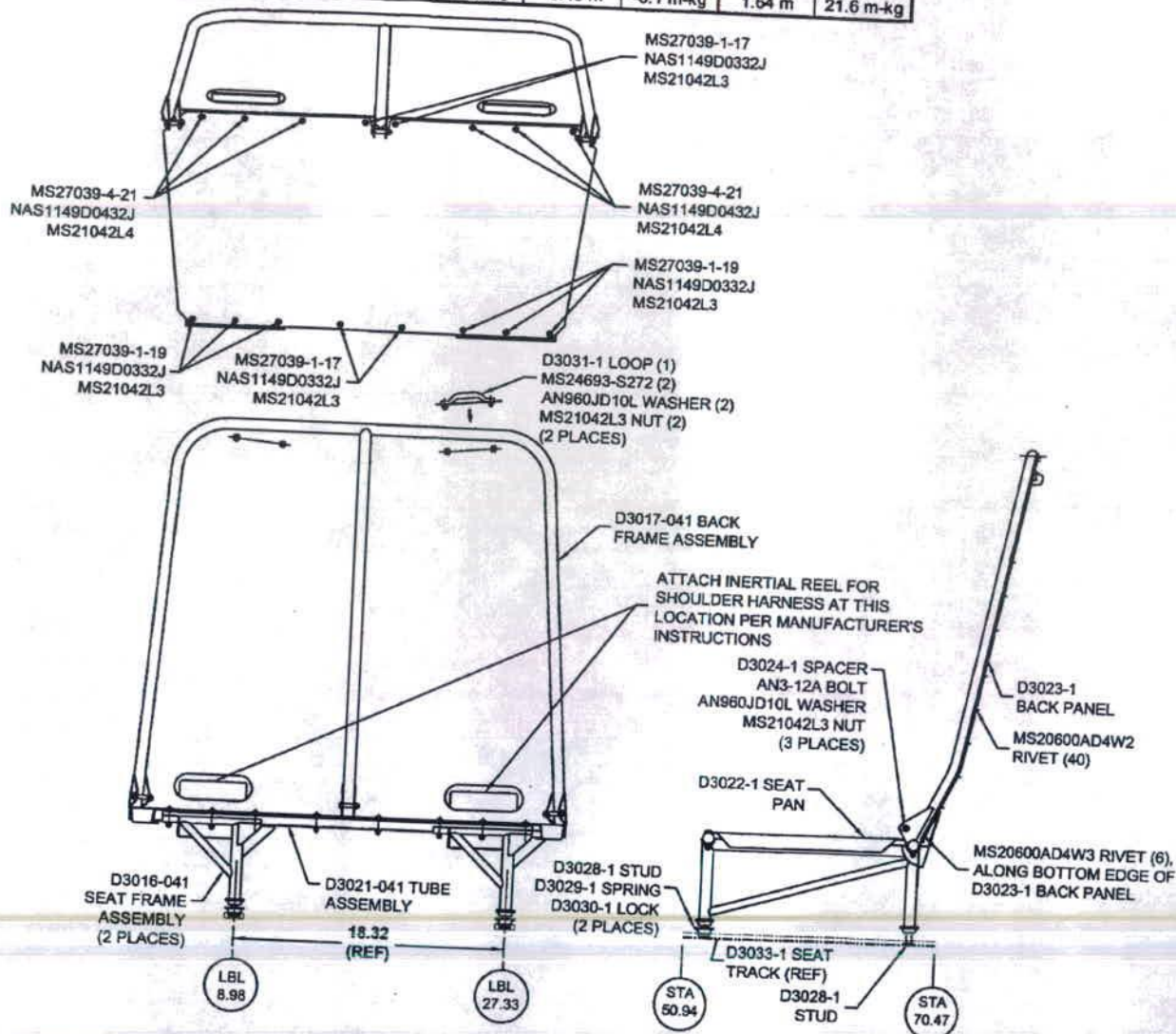
A	NEW ISSUE.		JPH	10.01.21
REV.	DESCRIPTION		BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	<i>[Signature]</i>			
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A	
MFG. APPR.	N/A	DSI 9498	SHEET 1 OF 2	
APPROVED	<i>[Signature]</i>	TITLE	SCALE	
DE APPR.	<i>[Signature]</i>	SEAT REINF; IIN & ICA UPDATE	NTS	
DATE	10.01.21		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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CHANGE:

THE FOLLOWING WEIGHT AND BALANCE INFORMATION IS FOR THE D350-689-011 DUAL HIGH BACK SEAT AT CHANGE 003 (OR LATER) AND THE D350-689-021 DUAL HIGH BACK SEAT AT CHANGE 002 (OR LATER).

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-689-011	27.6 lb	-18.2 in	-502 in-lb	60.7 in	1675 in-lb
Dual High Back Seat Installation	12.5 kg	-0.46 m	-5.8 m-k-g	1.54 m	19.3 m-k-g
D350-689-021 Dual High Back Seat	29.2 lb	-18.2 in	-531 in-lb	60.7 in	1772 in-lb
Installation, LH Fwd Position	13.2 kg	-0.46 m	-6.1 m-k-g	1.54 m	20.3 m-k-g
D350-689-021 Dual High Back Seat	29.2 lb	-18.2 in	-531 in-lb	64.7 in	1889 in-lb
Installation, LH Aft Position	13.2 kg	-0.46 m	-6.1 m-k-g	1.64 m	21.6 m-k-g



REF FIGURE 6 (IIN-350-689)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-Q-01

APPROVED

BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.01.21
CERT. NO.: SH02-33
ISSUE NO.: 1

DESIGN *[Signature]*
DRAWN *[Signature]*
CHECKED *[Signature]*
MFG. APPR. N/A
APPROVED *[Signature]*
DE APPR. *[Signature]*
DATE 10.01.21

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9498
REV. A
SHEET 2 OF 2
TITLE SEAT REINF; IIN & ICA UPDATE
SCALE NTS

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